

Date: Sunday, 12/4/2005 12:48:22 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 350 BASKET BASE (SHORT)		
Job Number	: 25094A					
Estimate Number	: 10209					
P.O. Number	: N/A			Part Number	: D3265041	
This Issue	: 12/4/2005 S.O. No. : N/A			Drawing Number	: D3265 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: B	
Previous Run	: 25093A			Material	: N/A	
Written By	: See Comment Below			Due Date	: 1/30/2006	
Checked & Approved By	: See Above User & Date			Qty:	1 Um: Each	
Comment	: Est Rev:C Re-Format 05-11-03 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D31661	Basket Hoop	
		Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s) Qty 3 D3166-1 Basket Hoop Batch: B26259	AA 06/04/17
2.0	M304TS0750W065	304 SQ Tube.75x.75x.065W	
		Comment: Qty.: 19.2150 f(s)/Unit Total : 19.2150 f(s) 3/4" x 3/4" x 0.063" wall 304/316 SS tubing. (M304TS0.750W.065) (M100282 → 82 1/2") Batch: (M100560 → 82 1/2") (M100023 → 54 1/2")	AA 06/04/17
3.0	D22323	Basket Hinge	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch	AA 06/04/17
	2 D2232-3	Hinge bracket B259237	
4.0	D2325	Support Gusset (350 Bask)	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Qty Part Number Description Batch	AA 06/04/17
	4 D2325	Support Gusset B25687	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0 D23273 Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2327-3	Bushing	B25823

AD 06/04/17

6.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2581	Mounting Bracket	B26204

AD 06/04/17

7.0 D34425 Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3442-5	Shim	B24246

AD 06/04/17

8.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 26.0000 sf(s)/Unit Total : 26.0000 sf(s)

Pick:

Qty	Part Number	Description	Batch
26sf	M304EX0.75-16F	Expanded Metal	B26100722

AD 06/04/17

9.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-CUT (3) D2235-1 FROM D3166-1

2-Drill hole in D3265-3 as per Dwg D3265

3-Remove all markings from material

4-Weld as per Dwg D3265 using Welding Table and corner JigDeburr as required

AD 06/04/17

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QA: N/C Closed: _____ Date: _____

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Description :

10.0 QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

PD 06-04-24

11.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

2:00 a.m. 06/04/25 01

12.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Seal support gusset seam with White Sikaflex-291

Batch: M100480

Expiry date: 11/2006

SAP 06:05:02

01

13.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Job Completion



Inspection Level 21

06/05/03 01

U 06/05/03

01

WORK ORDER CHANGES

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DATE	STEP									

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